



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBWA353A04 Job Sheet 190393



Part No: RBWA353A04

Job Qty: 2 pcs

Part Name: Pmc Oil Filling Quick Disconnect



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description: \$10P

Note: DWG RBWA353A04 Rev 4 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	3/15/19		0.00	2.00	Small Fab - 1		DAS 71 9-89 9-4-25
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	3/15/19		0.00	0.00	QC 5 - 10		DAS 40 9-89 APR 26 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	2 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Container No: S175732



Part: RBWA353A04

Job No: 190393

Serial No/Batch: S175732

Revision: 4

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/26/19

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	2 pcs	3/15/19	0.00 0.00	QC 21 - SA - 21	DAG
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

APR 29 2019

Part Op 110 - Small Fab - 1-Assemble as per DWG. Sheet . 2-Engrave 1632T22 tag using marktronic engraver as per DWG. 3-Descriptions: Fabricate and attach lanyard as per DWG.

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container	
1632T22	Aluminum Tag 1" X 2" X 0.04"	2 pcs (1 ea)	110-Small Fab - 1	✓ S050751	78
2619	Spring Rnd 3/4"	2 Ea (1 ea)	110-Small Fab - 1	✓ S075045	27
3896T31	Ferule 1/16 X 3/8" - Aluminum	4 Ea (2 ea)	110-Small Fab - 1	✓ S137368	26 (SF)
50715K179	Female Pipe Adapter SS	2 Ea (1 ea)	110-Small Fab - 1	✓ S116871 S128824	44
91665A350	Retaining Ring, 7/16" Shaft	2 Ea (1 ea)	110-Small Fab - 1	✓ S046069	52
9262K613	O-Ring 13mm OD x 1mm	2 Ea (1 ea)	110-Small Fab - 1	✓ S046049	47
CL-2-C	Lanyard Wire	.8400 ft (.42 ea)	110-Small Fab - 1	✓ S119833	26 (SF)
RBWA353A04-01	Cap	2 Ea (1 ea)	110-Small Fab - 1	✓ S155611	137
RBWA353A04-02	Sleeve	2 pcs (1 ea)	110-Small Fab - 1	✓ S146133	137
RBWA353A04-03	Barb	2 pcs (1 ea)	110-Small Fab - 1	✓ S140141	137
RBWA353A04-05	Quill	2 pcs (1 ea)	110-Small Fab - 1	✓ S136861	137
RBWA353A04-06	Cap	2 pcs (1 ea)	110-Small Fab - 1	✓ S159837	137
RBWA353A04-07	Valve	2 pcs (1 ea)	110-Small Fab - 1	✓ S137129	93
RBWA353A04-08	Screw (Modified B/O)	4 pcs (2 ea)	110-Small Fab - 1	✓ S057743	94
S1030	Spring .025 Wire: .300 O.D X .5 free length	2 Ea (1 ea)	110-Small Fab - 1	✓ S107889	25

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	1632T22	2	92	0
	2619	2	37	0
	3896T31	4	796	0
	50715K179	2	7	0
	91665A350	2	16	0
	9262K613	2	83	0
	CL-2-C	1	484	0
	RBWA353A04-01	2	1	0
	RBWA353A04-02	2	10	0
	RBWA353A04-03	2	12	0
	RBWA353A04-05	2	11	0
	RBWA353A04-06	2	1	0
	RBWA353A04-07	2	11	0
	RBWA353A04-08	4	15	0
	S1030	2	5	0

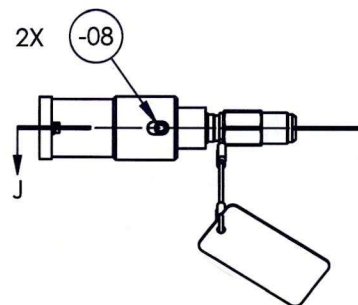
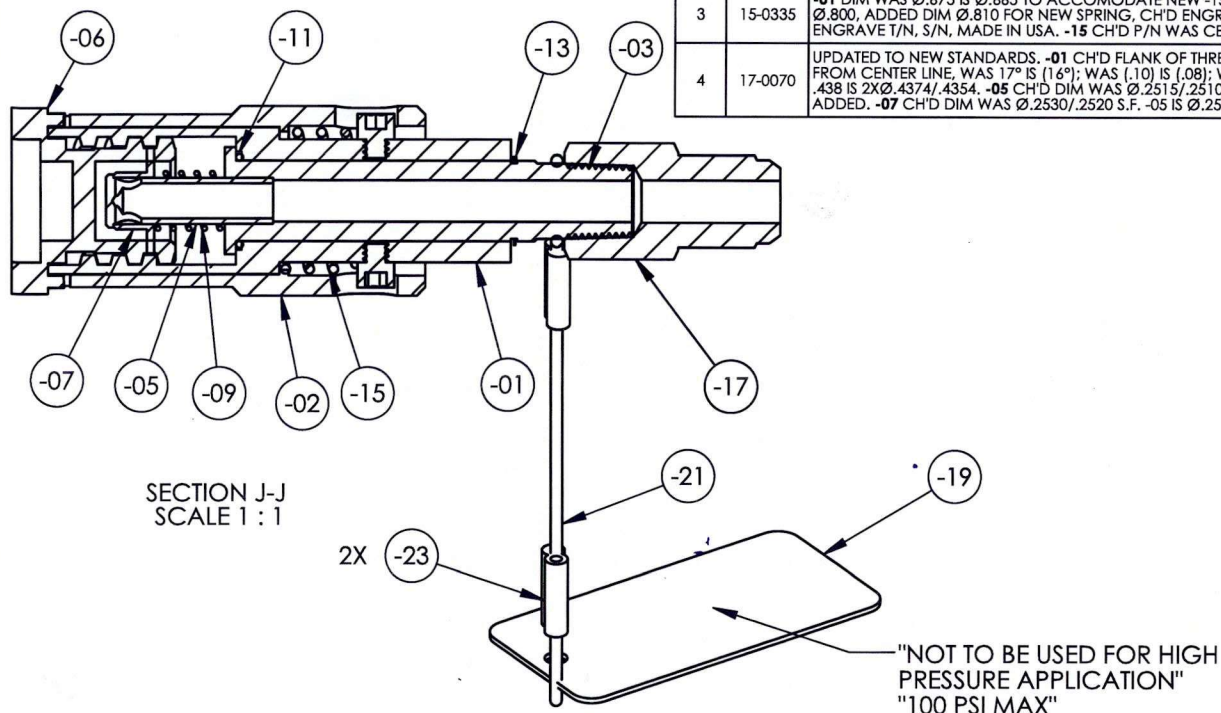
Part Specifications

Specifications could not be found.

Plex 2/8/19 8:36 AM Dart.Macdonald.Dara

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED ASSEMBLY	2/22/2011	JAG	
2		DELETED -19, -21, & -23 CH'D -15 FROM HOSE & -17 FROM HOSE CLAMP. ADDED -19, -21, & -23. -01 CH'D TO CLEAR ANODIZE. -02 CH'D TO CLEAR ANODIZE. CH'D -03 THRU HOLE FROM Ø.17, CH'D DESIGN ADDED 1/8 NPT -27 FOR FITTING, CH'D -05 ID FROM Ø.14 & CH'D LIMIT DIMENSION FROM Ø.2510-.2514 S.F. -07, CH'D -07 ID LIMIT DIM. FROM Ø.2515-.2520 & S.F. -05 PER D.W.	1/17/2012	RJC	DW
2A		-03 REMOVED X.50 DEPTH FROM 1/8 NPT	1/3/2013	BIM	GE
3	15-0335	-01 DIM WAS Ø.675 IS Ø.665 TO ACCOMODATE NEW -15 SPRING. -02 CH'D DIM'S WAS 2X Ø.800 IS Ø.800, ADDED DIM Ø.810 FOR NEW SPRING, CH'D ENGRAVE NOTE WAS ENGRAVE T/N TO FIT IS ENGRAVE T/N, S/N, MADE IN USA. -15 CH'D P/N WAS CENTURY SPRING #B15-66 IS 2619.	10/13/2015	RJC	JAG
4	17-0070	UPDATED TO NEW STANDARDS. -01 CH'D FLANK OF THREAD START WAS ON CENTERLINE, IS 5° OFFSET FROM CENTER LINE, WAS 17° IS (16°); WAS (.10) IS (.08); WAS .101 IS .100. -03 CH'D DIM WAS 2X Ø.438 IS 2X Ø.4374/.4354. -05 CH'D DIM WAS Ø.2515/.2510 S.F. -07 IS Ø.2515/.2510 (S.F. -07). -06 ADDED. -07 CH'D DIM WAS Ø.2530/.2520 S.F. -05 IS Ø.2530/.2520 (S.F. -05).	3/21/2017	SM	JAG

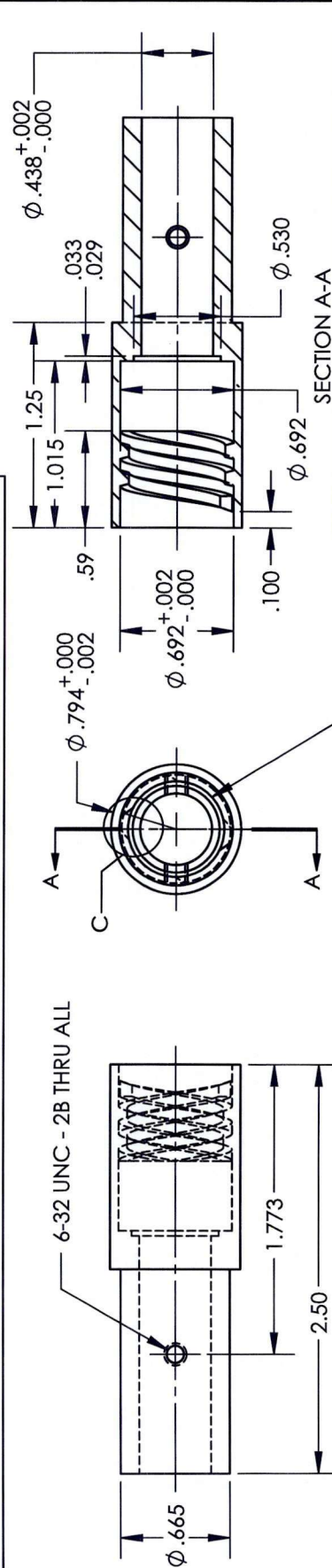
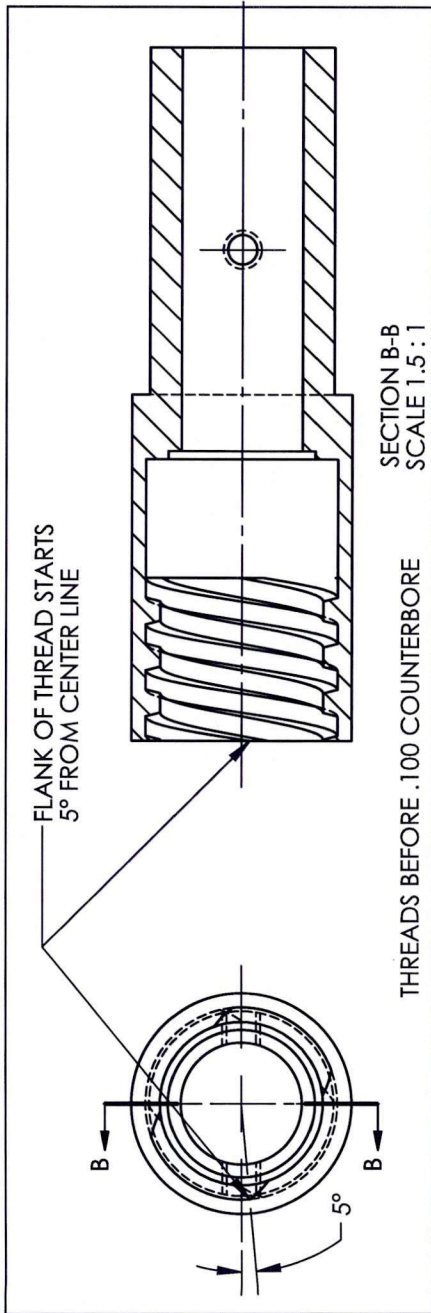


B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	-01	1	CAP	6061		2
	-02	1	SLEEVE	6061		3
	-03	1	BARB	303/304 S.S.		4
	-05	1	QUILL	303/304 S.S.		5
	-06	1	CAP	6061		6
	-07	1	VALVE	303/304 S.S.		7
	-08	2	SCREW	S.S.	6-32 X 1/8 (MCMaster-CARR #92196A139) MODIFIED	8
B/O	-09	1	SPRING	MUSIC WIRE	Ø.025 WIRE: Ø.300 OD X .5 FREE LENGTH (RIED #S1030)	1
B/O	-11	1	O-RING	BURNA-N	Ø13mm OD X 1mm (MCMaster-CARR #926K613)	1
B/O	-13	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT (MCMaster-CARR #91665A350)	1
B/O	-15	1	SPRING	SPRING STEEL	Ø.78 (CENTURY SPRING #2619)	1
B/O	-17	1	FEMALE PIPE ADAPTER	S.S.	MCMaster-CARR #50715K179	1
	-19	1	TAG	ALUMINUM	1/32 X 1 X 2	1
B/O	-21	1	LANYARD	COATED GALV. STEEL	(7X7 CABLE) Ø1/16 X 5in. (CARR LANE #CL-2-2)	1
B/O	-23	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	1

			TITLE	
			PMC OIL FILLING QUICK DISCONNECT	
			DWG NO.	REV
			RBWA353A04	4
MAT'L		UNLESS OTHERWISE SPECIFIED		
HEAT TREAT		DIMENSIONS ARE IN INCHES		
FINISH		.XXX ± .005 FRACTIONS ± 1/8		
SPEC		.XX ± .01 ANGLES ± 5°		
DRAWN BY:		1. BREAK ALL SHARP EDGES		
CHECKED:		.015 x 45° OR .015R		
OPPS APPR:		2. DIMENSIONAL LIMITS APPLY		
QA APPR:		AFTER PLATING		
APPROVED:		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		
SCALE		USED ON MODEL		
1:3		AGUSTA HELICOPTERS		
DATE		SHEET 1 OF 8		
2/22/2011				

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REVISIONS			
REV	ECR	DESCRIPTION	
2		-01 CHD TO CLEAR ANODIZE.	APPROVED
3	15-0335	-01 DIM WAS $\phi .675$ IS $\phi .665$ TO ACCOMMODATE NEW .15 SPRING.	DATE 1/17/2012 RJC DW
4	17-0070	-01 CHD FLANK OF THREAD START WAS ON CENTERLINE, IS 5° OFFSET FROM CENTER LINE, WAS 17° IS (16°); WAS (.10) IS (.08); WAS .101 IS .100.	DATE 10/13/2015 RJC JAG
			DATE 3/21/2017 SM JAG



DART AEROSPACE

TITLE: PMC OIL FILLING QUICK DISCONNECT

DWG NO.: RBWA353A04-01

REV: 4

MAT'L: 6061

HEAT TREAT: CLEAR ANODIZE

FINISH: SPEC MIL-A-8625, TYPE II, CLASS I

DRAWN BY: GILBERT

CHECKED: DD 03/22/2017

OPPS APPR: AA 03/28/2017

QA APPR: JL 03/29/2017

APPROVED: JAG 04/03/2017

SCALE: 1:1

DATE: 2/22/2011

SHEET 2 OF 8

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS ARE 16
XX ± .01 ANGLES 5°
SURFACES = 125/
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL LIMITS APPLY
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009
USED ON MODEL

AGUSTA HELICOPTERS

DETAIL C
SCALE 4:1
2 PLACES

REMOVE THREAD START
TO FULL THREAD WIDTH
AS SEEN IN ISO

(.08)

(16°)

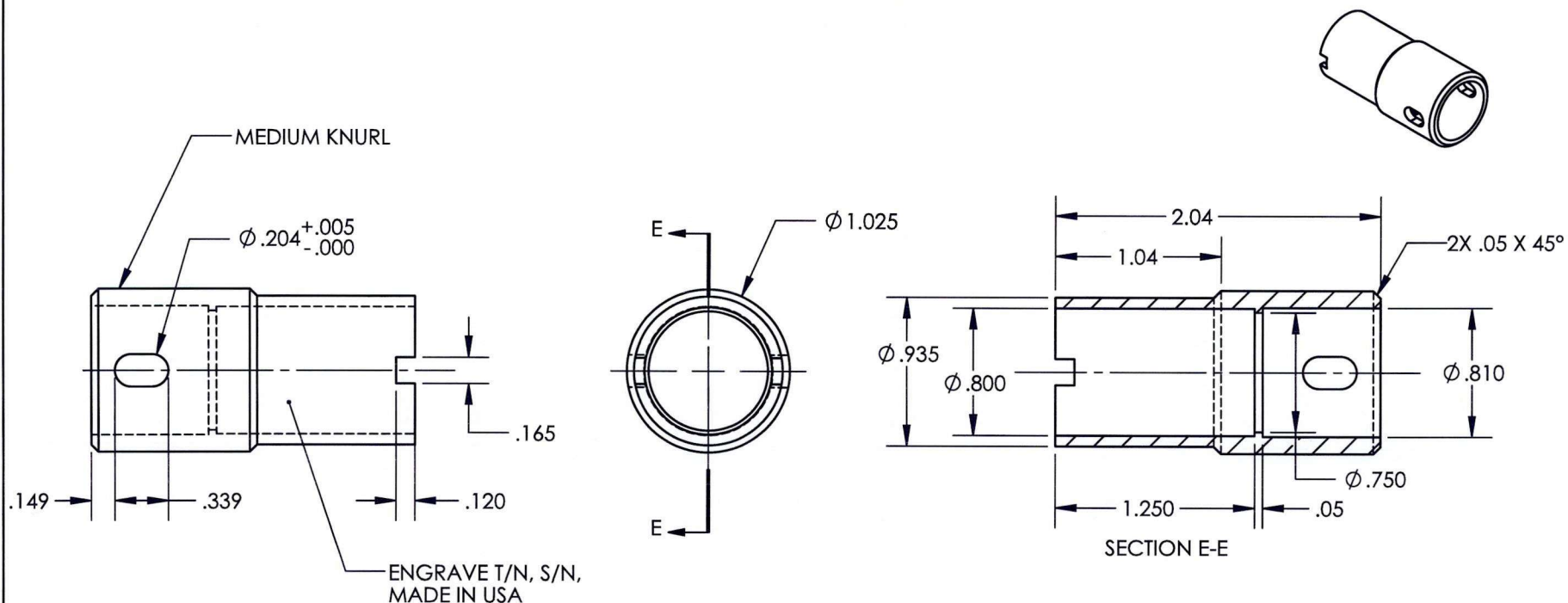
11/16-6 STUB ACME
DOUBLE LEAD

(-01)

CAP

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-02 CH'D TO CLEAR ANODIZE.	1/17/2012	RJC	DW
3	15-0335	-02 CH'D DIM'S WAS 2X Ø.800 IS Ø.800. ADDED DIM Ø.810 FOR NEW SPRING, CH'D ENGRAVE NOTE WAS ENGRAVE T/N TO FIT IS ENGRAVE T/N, S/N, MADE IN USA.	10/13/2015	RJC	JAG



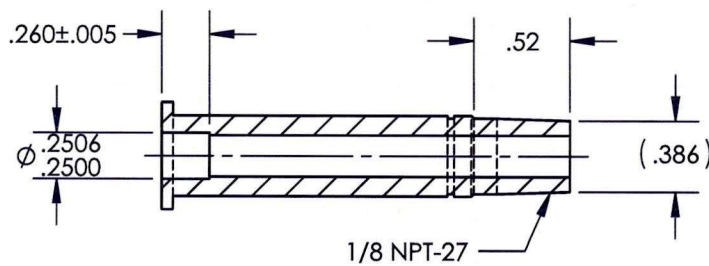
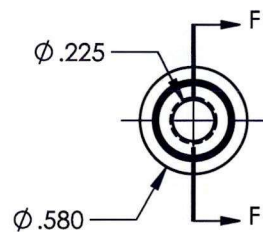
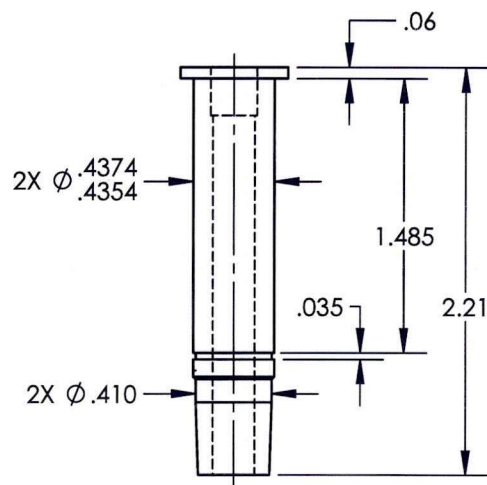
(-02)

SLEEVE

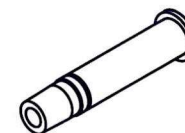
DART AEROSPACE	
TITLE PMC OIL FILLING QUICK DISCONNECT	
DWG NO. RBWA353A04-02	REV 4
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH CLEAR ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS I	.X ± .1 SURFACES = 125/✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/22/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 03/28/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 03/29/2017	USED ON MODEL
APPROVED: JAG 04/03/2017	AGUSTA HELICOPTERS
SCALE 1:1	DATE 2/22/2011
SHEET 3 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-03 CH'D THRU HOLE FROM Ø.17, CH'D DESIGN ADDED 1/8 NPT -27 FOR FITTING.	1/17/2012	RJC	DW
2A		-03 REMOVED X.50 DEPTH FROM 1/8 NPT.	1/3/2013	BIM	GE
4	17-0070	-03 CH'D DIM WAS 2X Ø .438 IS 2XØ.4374/.4354.	3/21/2017	SM	JAG



SECTION F-F

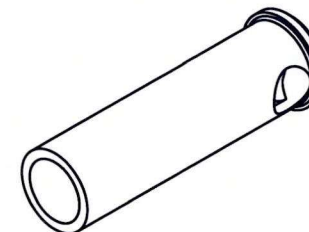
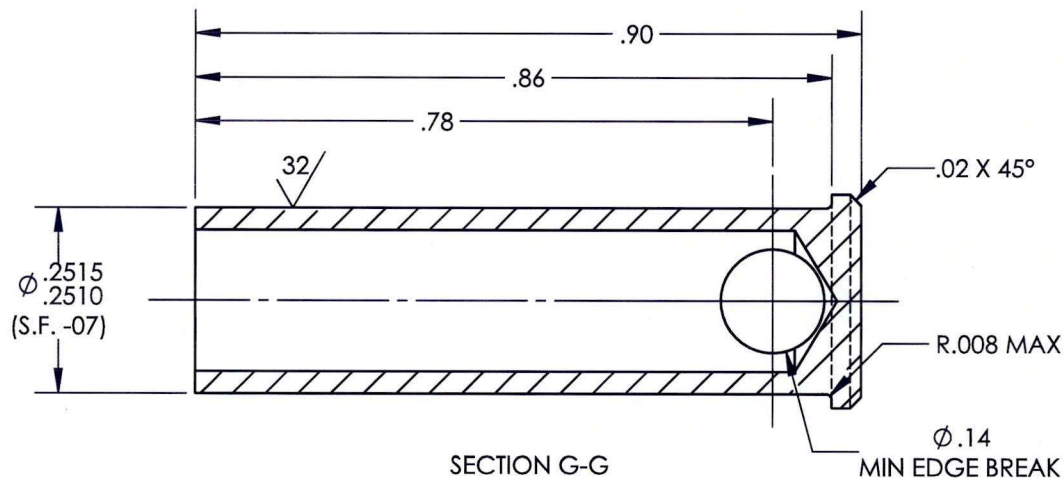
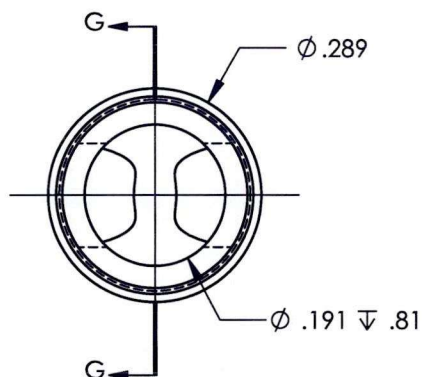


(-03)
BARB

DART AEROSPACE	
TITLE PMC OIL FILLING QUICK DISCONNECT	
DWG NO. RBWA353A04-03	REV 4
MAT'L 303/304 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: DD 03/22/2017	.015 x 45° OR .015R
OPPS APPR: AA 03/28/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 03/29/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: JAG 04/03/2017	USED ON MODEL
SCALE 1:1	AGUSTA HELICOPTERS
DATE 2/22/2011	SHEET 4 OF 8

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-05 CH'D ID FROM Ø.14 & CH'D LIMIT DIMENSION FROM Ø.2510-.2514 S.F. -.07.	1/17/2012	RJC	DW
4	17-0070	-05 CH'D DIM WAS Ø.2515/.2510 S.F. -.07 IS Ø.2515/.2510 (S.F. -.07).	3/21/2017	SM	JAG



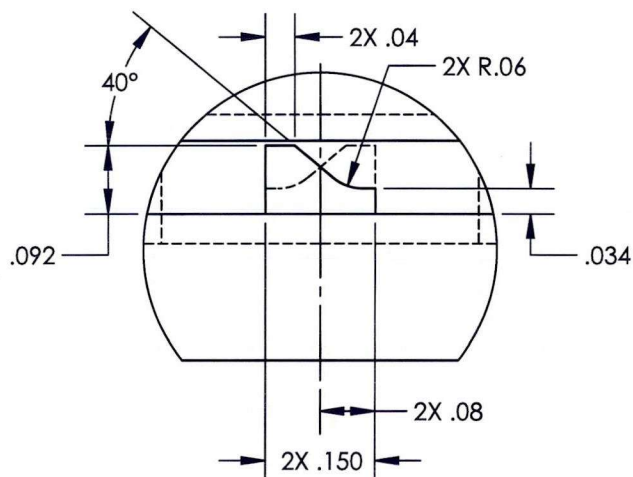
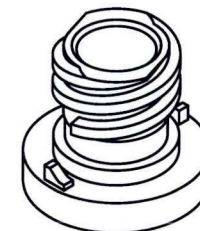
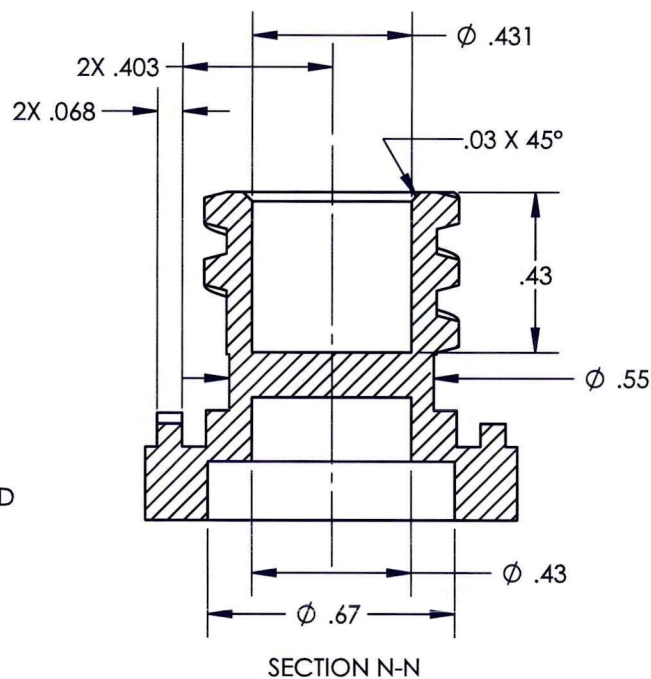
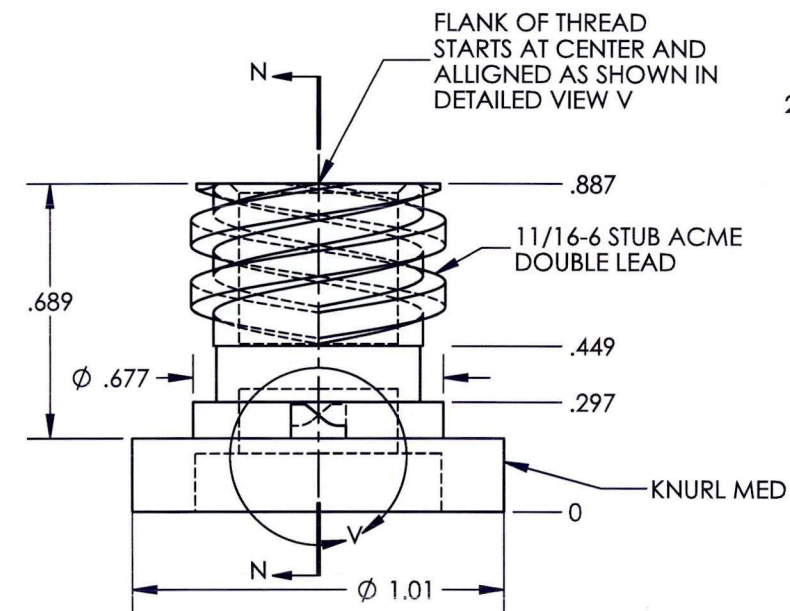
(-05)

QUILL

DART AEROSPACE	
TITLE PMC OIL FILLING QUICK DISCONNECT	
DWG NO. RBWA353A04-05	REV 4
MAT'L 303/304 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	X ± .1 SURFACES = 125/
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/22/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 03/28/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 03/29/2017	USED ON MODEL
APPROVED: JAG 04/03/2017	AGUSTA HELICOPTERS
SCALE 4:1	DATE 2/22/2011 SHEET 5 OF 8

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	17-0070	-06 ADDED.	3/21/2017	SM	JAG



DETAIL V
REPEAT 2X
SCALE 4 : 1

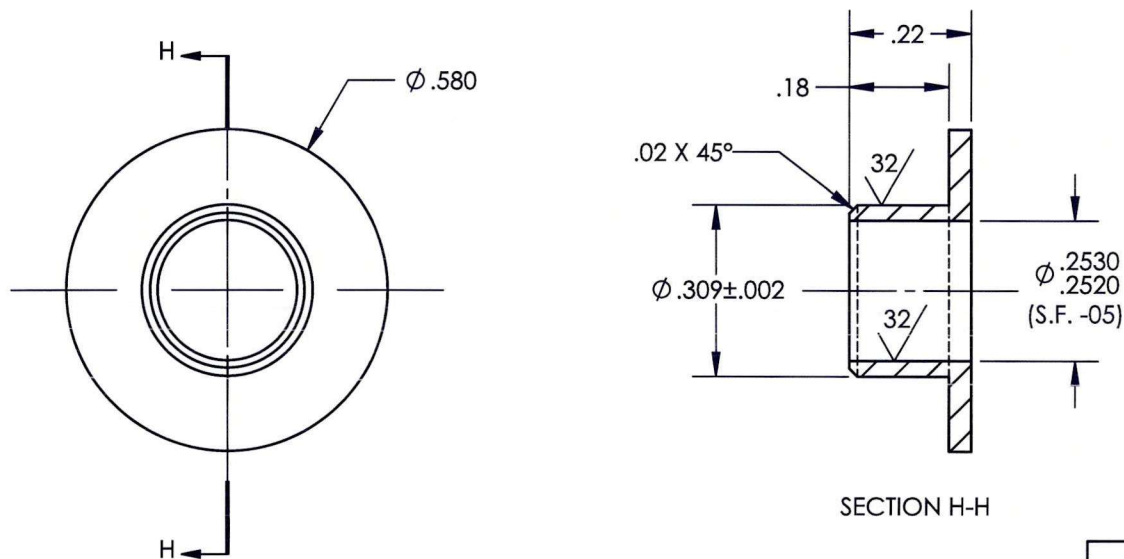
(-06)

CAP

DART AEROSPACE	
TITLE PMC OIL FILLING QUICK DISCONNECT	
DWG NO. RBWA353A04-06	REV 4
MAT'L 6061 HEAT TREAT FINISH BLACK ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/√	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: MACKOVJAK CHECKED: DD 03/22/2017 OPPTS APPR: AA 03/28/2017 QA APPR: JL 03/29/2017 APPROVED: JAG 04/03/2017	
USED ON MODEL AGUSTA HELICOPTERS	
SCALE 2:1	DATE 6/16/2016
SHEET 6 OF 8	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2		-07 CH'D ID LIMIT DIM. FROM Ø.2515-.2520 & S.F. -.05 PER S.E. INCREASES STEP FROM .16 TO .18.	1/17/2012	RJC
4	17-0070	-07 CH'D DIM WAS Ø.2530/.2520 S.F. -.05 IS Ø.2530/.2520 (S.F. -.05).	3/21/2017	SM



SECTION H-H

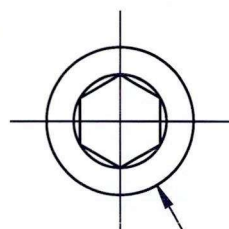
(-07)

VALVE

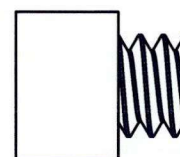
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TITLE PMC OIL FILLING QUICK DISCONNECT	
DWG NO. RBWA353A04-07	REV 4
MAT'L 303/304 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	X ± .1 SURFACES = 125/✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/22/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 03/28/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 03/29/2017	USED ON MODEL
APPROVED: JAG 04/03/2017	AGUSTA HELICOPTERS
SCALE 3:1	DATE 2/22/2011
SHEET 7 OF 8	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



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(-08)

SCREW



TITLE		PMC OIL FILLING QUICK DISCONNECT	
DWG NO.		RBWA353A04-08	
REV		4	
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED		
HEAT	DIMENSIONS ARE IN INCHES		
TREAT	XXX ± .005 FRACTIONS ± 1/8		
FINISH	XX ± .01 ANGLES ± 5°		
SPEC	X ± .1 SURFACES = 125/		
DRAWN BY:	GILBERT	1. BREAK ALL SHARP EDGES	
CHECKED:	DD 03/22/2017	.015 x 45° OR .015R	
OPPS APPR:	AA 03/28/2017	2. DIMENSIONAL LIMITS APPLY	
QA APPR:	JL 03/29/2017	AFTER PLATING	
APPROVED:	JAG 04/03/2017	3. INTERPRET DIM AND TOL PER	
SCALE	4:1	ASME Y14.5M-2009	
DATE	2/22/2011	USED ON MODEL	
SHEET 8 OF 8		AGUSTA HELICOPTERS	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:			